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(54) CYLINDER SLEEVE STRUCTURE

(57) Abstract:

PROBLEM TO BE SOLVED: To reduce a burr generation area, to completely remove the burr in an internal working process of a cylinder, and to improve the molding efficiency.

SOLUTION: In a structure of a cylinder sleeve S of casted iron or the like integrally cast on a cylinder block 7 made of a aluminum or the like, an outer peripheral part of a point of the cylinder sleeve S is slightly largely chamfered in advance, a margin for working an inner peripheral surface of the cast cylinder sleeve S is formed by cutting, and the chamfering work for preventing the interference of a working tool or the like is executed on an inner peripheral part (a) of a point of

the cylinder sleeve S to obtain a sleeve end surface free from a flat part. According to this structure, the burr formed on the sleeve end surface in the casting can be removed by the internal working process of the sleeve.

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